

Monday, 20/04/2009 9:58:13 AM

Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 47272  
 Estimate Number : 13867  
 P.O. Number :  
 This Issue : 20/04/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : R & D SM/MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By : 2009.04.20  
 Comment : Est Rev:A 09-04-15 new issue EC verified by:DD

Drawing Name : CLIP ASSEMBLY  
 Part Number : D3934041  
 Drawing Number : D3934 PROTO 09.04.21  
 Project Number : N/A  
 Drawing Revision : PROTO  
 Material :  
 Due Date : 27/04/2009 Qty: 6 Um: Each

## Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.0221 sf(s)/Unit Total: 0.1323 sf(s)

304/316 .040 Sheet

Batch: 109088 R 9-4-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3934

Dwg Rev: PROTO R 9-4-20Prog Rev: TYPE2-Deburr if necessary M. h. 09/04/20 (8) (8x)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

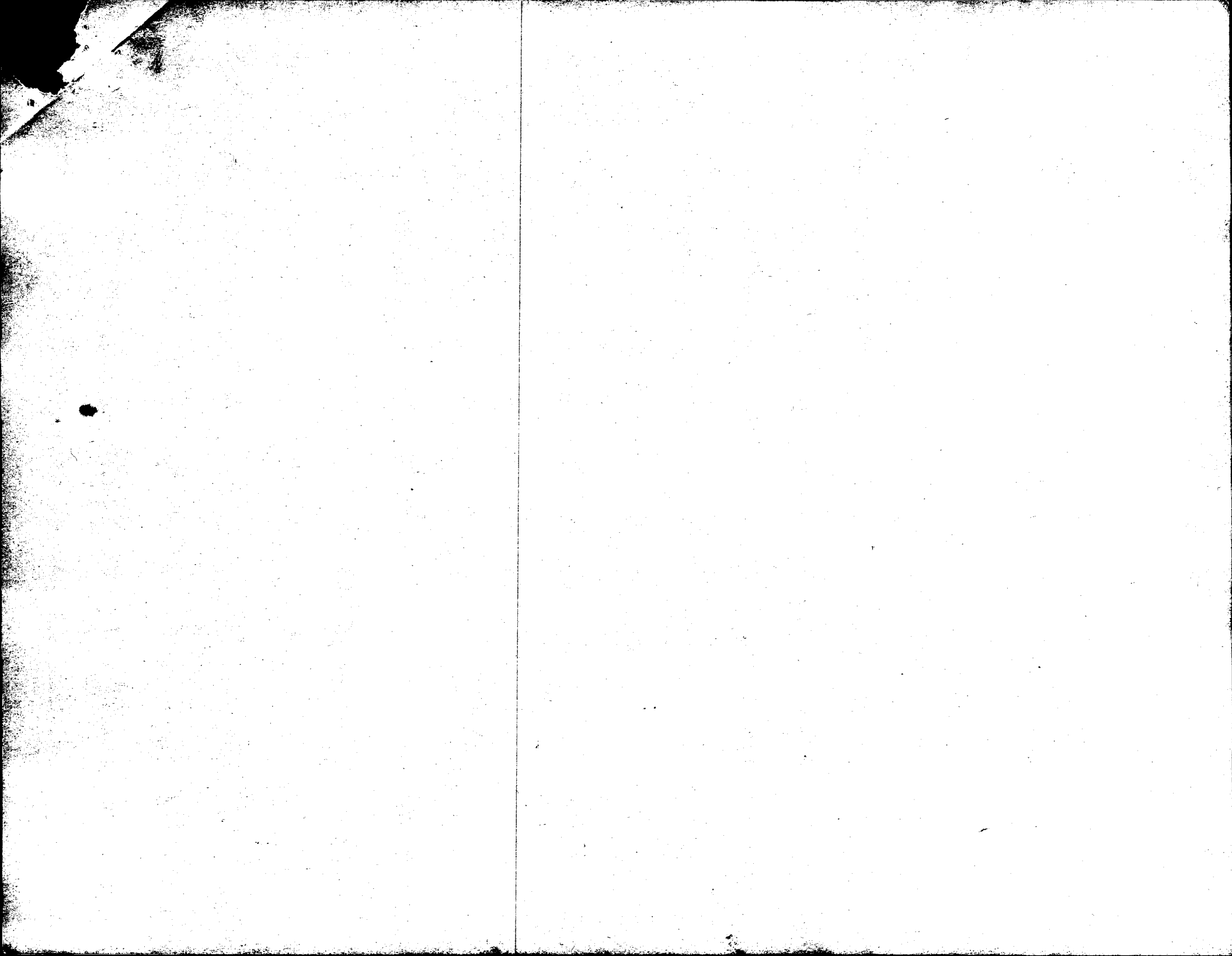
Comment: SECOND CHECK R 9-4-20 (8)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Bend as per dwg D3934 SB 09/04/21 (8)



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLIP ASSEMBLY

Job Number: 47272

Part Number: D3934041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nutplate

batch: M110704

8.0

MS20426AD32

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch: M1173 M7681

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink and assemble as per dwg D3934

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: \_\_\_\_\_

Eng's use testing

PH 09.04.21

→  
PTG

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00276  
MF  
09-06-05

09.04.24

055

- 1) - 03934-1 dim  $\approx 1.86$  ! now 0.69  
a) - Trim 03934 Rev4, (prototype dated 09.04.21)  
to allow for 1) above

OK PA  
09.04.24  
030424

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-781

Job #: 00276

Date: 09.04.17

Product Name: Cabin Floor Protectors

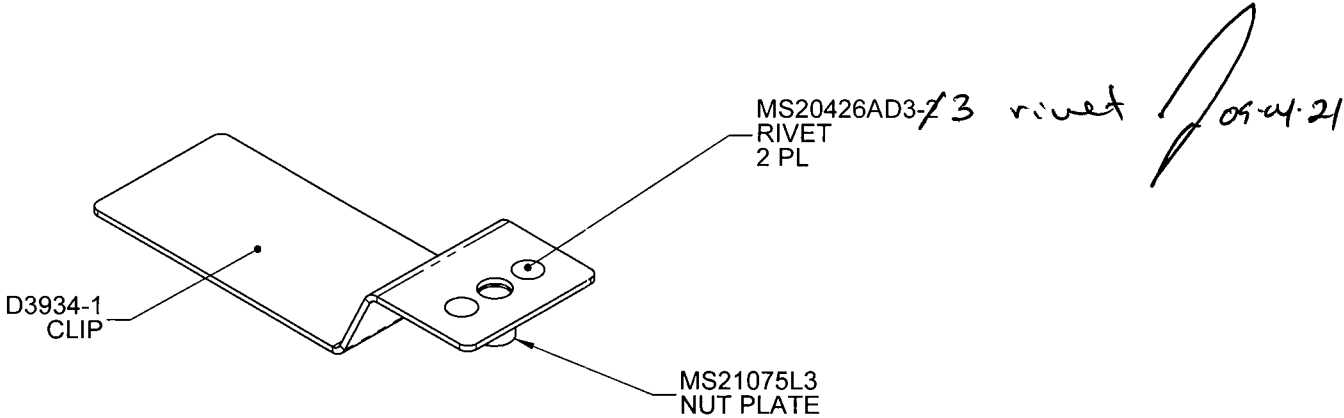
Requested By: PH 

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
6	D3934-041		Clip Assembly	09.04.17	Y	ASAP	Includes D3934-1 Clip	



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-2	RIVET



**D3934-041 CLIP ASSEMBLY**

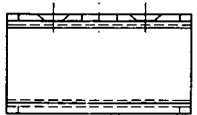
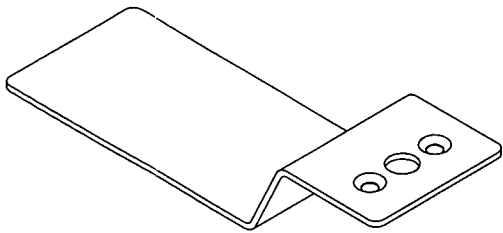
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47272

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.04.17

SUPERCEDED ON  
09.04.21

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3934	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSEMBLY	NTS
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WORK ORDER  
NO. 4078

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

09.04.17

SUPERSEDED ON  
09.04.21

**D3934-1F FLAT PATTERN**

**D3934-1 CLIP**  
(MAKE FROM D3934-1F)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
20 GAUGE (0.038 THICK)  
REF DART SPEC M304S20GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.03 lbs

DESIGN	PEJ	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PEJ		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3934	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSEMBLY	NTS
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# Receiving Report

Date: 8/25  
Supplier: MAGNA

Batch No: M109088  
Dart P/O: 7044

Packing Slip: Yes ☒ No ☐  
Invoice: Yes ☐ No ☒  
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐  
Waybill Attached: Yes ☐ No ☒  
Shipment Complete: Yes ☒ No ☐ N/A ☐  
QC6 Inspection 8/25/02 N/A ☐  
Work Order                      N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12                     

Production/Admin:                       
Date: 8/10/02  
Received/Costing: 808774  
Initial:                     

Location                     

FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED SEP 08 2008

Sub-Total  
G.S.T.

1405.00  
70.25

**TOTAL →**

1475.25

LES D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.  
PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME  
NT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.  
MINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.  
PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD  
CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

# DART

## Purchase Order

Date Aug 28, 2008	Page 1
Purchase Order Number PO00007044	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAKED**  
6/28/08

### Vendor Address:

Magna Stainless  
525 avenue Meloche  
Dorval, QC H9P 2W2  
Canada  
Phone (800) 363-6646  
Fax (514) 631-0013

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Aug 28, 2008	N30	yours	Aug 29, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 320.0000	M304S20GA	304/316 .040 Sheet Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/29/2008	No	4.062500	sf	1,300.00
✓ 20.0000	M6061T6TR40X20W 0.125	6061-T6 Rect Tube 4.0 x 2 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 RECTANGULAR TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128, 4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	28/29/2008	No	4.000000	f	80.00

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

### Comments:

Tax Summary:  
GST  
ONTPST

69.00  
0.00

Less:  
included tax

0.00

Subtotal

1,380.00

Total tax

69.00

Total purchase order in

CAD Dollars

1,449.00

Entered By: CL CLAVOIE

Approved By: 

# **MAGNA**

MAGNA STAINLESS DIV. DE CSM INC.  
525 MELOCHE AVE.  
DORVAL, QUEBEC H9P 2W2  
(514) 631-1211 FAX: (514) 631-0013

COMMANDE...  
SALES ORDER

0174638

NDU À /  
D TO:

LIVRÉ À /  
SHIP TO:

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

DART AEROSPACE LTD  
270 ABERDEEN STREET  
IAWKESBURY  
ONTARIO

K6A 1K7

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.	
0174638		DART		7044		613 632-5200		632-1053	
LIVRÉ VIA - SHIP VIA		CONDITIONS - TERMS		DATE COMMANDEE DATE ORDERED		DATE REQUISE DATE REQUIRED		DATE LIVRÉE DATE DELIVERED	
NIR:R-557065-1		NET 30		Aug-28-08		Aug-29-08		15 26 EB	
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D		<input type="checkbox"/>		CONTRÔLE DE QUALITÉ DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D		<input type="checkbox"/>		PRÉPAYÉ PREPAID <input type="checkbox"/>	
A PERCEVOIR COLLECT <input type="checkbox"/>									
QUALITÉ - QUALITY		UNITÉ UNIT		N° DE COULÉE HEAT NUMBER		DESCRIPTION		QTE LIVRÉE QTY SHIPPED	
COMMANDEE ORDERED		A VENIR - B/O						PRIX PAR PRICE PER	
10		pcs		7507		304-2B SHEET 20GA 48 X 96		104	
1		pcs		7900		6061-T6 ALUM 2 X 4 X .120"SQC"		3 1/4	
1.00		Lot		POSITIVE RECALL		Fuel Surcharge POSITIVE RECALL EFFECTIVE 8/8/04 AUTH RELEASED 8/8/02 DATE		10 pcs 1 pcs	
						TOTAL :		537 LBS	

LIBRE DE PAQ.  
LIBER OF BOL'S

MTR-AVEC COMMANDE  
MTR'S WITH ORDER

POSTE  
MAIL

TÉLÉCOPIEUR  
FAX

\*\*PACKING SLIP / BON D'EMBALLAGE\*\*

ge: 1

15:18:00

20080828

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ  
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISION 'E' - 07/07 - FORM 2008



证书号: (2008) 质监字 (0213) 0312-号

# 产品质量证明书

## PRODUCT INSPECTION CERTIFICATE

ZPS

张家港浦项不锈钢有限公司

ZHANGJIAGANG POHANG STAINLESS STEEL CO., LTD.

地址: 中国江苏省张家港市塘桥镇江开发区

ADDRESS: Jiang Riverside Development Zone Zhangjiagang

City Jiangsu Province China

电话 (Tel): 86-512-58553660 传真 (Fax): 86-512-58554277

邮政编码 (P.C.): 215623

合同号码: -

Contract No.

订货方: POSCO ASIA CO., LTD

Order LTD

使用厂家: MAGANA

Customer

品名: COLD ROLLED STAINLESS

Commodity: STERLIN COIL

标准: ASTM A240/480

Specification

牌号: A240

Type

表面加工: NO. 2B

Surface Finish

证明书编号: 200806069



Certificate No.


发行日期: 2008-04-29

Date

序号 No	产品号 Product No	炉号 Heat No	产品尺寸 Product Size			张数 Number	重量 Weight Kg	拉伸试验 Tensile Test			表面 硬度 Hard ness Hv	弯曲 试验 Bend ing 180°	化 学 成 分 Chemical Composition (%)																	
			厚度 Thickness mm	宽度 Width mm	长度 Length mm			屈服强度 0.2% YS N/mm <sup>2</sup>	抗拉强度 TS N/mm <sup>2</sup>	延伸率 EL %			C	Si	Mn	P	S	NI	Cr	N	Mo	Cu								
1	LCD0631	SF08323	1.0	1219	C	0	5219	265	870	58	162		≤0.08	≤1.00	≤2.00	≤0.04	≤0.03	3.00~10.50	18.00~20.00											
			0.032				以下			白			0.049	0.49	1.08	0.032	0.005	8.03	18.17							0.18	0.10			

**FAX**

  Ms Ashley Dion  
514-631-0013  
Yoon Kany (Daewoo)  
905-268-2939  
DATE: 05/10/01



FAX

Mr. Ashley Dion  
514-631-0013  
Yoon Kany (Daewoo)  
905-244-2777  
DATE 05/2/08

备注 (Remarks):

1. 尺寸和表面: 合格

Size and Surface: Guaranteed

2. 拉伸试验: 方法符合 JIS Z 2241 标准; 试样规格为 JIS Z 2201 5号

Tensile Test: Technique accord with JIS Z 2241;

Sample Specification accord with No.5 of JIS Z 2201

3. 硬度试验: 方法符合 JIS Z 2244 标准

Hardness Test: Technique accord with JIS Z 2244

按证明所列产品均符合订单和标准的技术要求

WE HEREBY CERTIFY THAT THE MATERIAL  
HEREIN HAS BEEN MADE IN ACCORDANCE  
WITH THE ORDER AND SPECIFICATION

\*此报告仅可完全复制

\*The report can only be copied completely

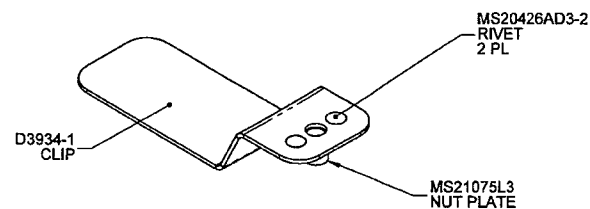
技术部

TECHNICAL DEPT.

ZHANGJIAGANG POHANG STAINLESS STEEL CO., LTD.

2. D. KANG  
Manager of Quality Team

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-2	RIVET



**D3934-041 CLIP ASSEMBLY**

SUPERCEDED ON  
09.04.22  
RJ

Prototype  
09.04.16  
RJ

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3934	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
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8 7 6 5 4 3 2 1

D

D

C

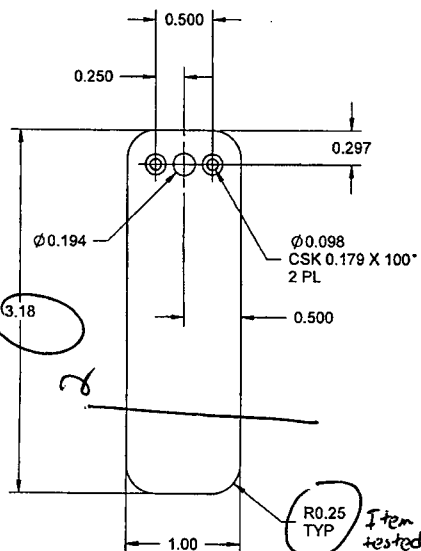
C

B

B

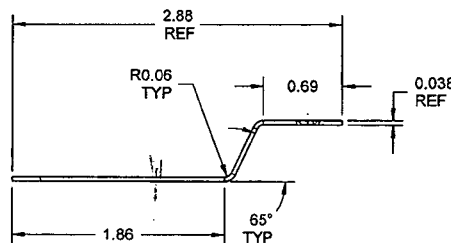
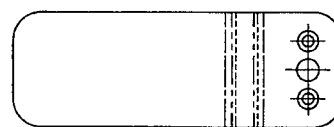
A

A

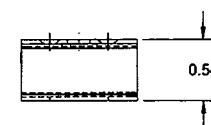
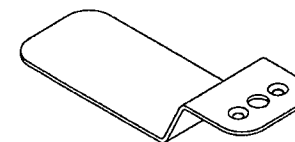


**D3934-1F FLAT PATTERN** (1)

09.04.22



**D3934-1 CLIP**  
(MAKE FROM D3934-1F)



SUPERCEDED ON

09.04.22

Prototype  
09.04.21

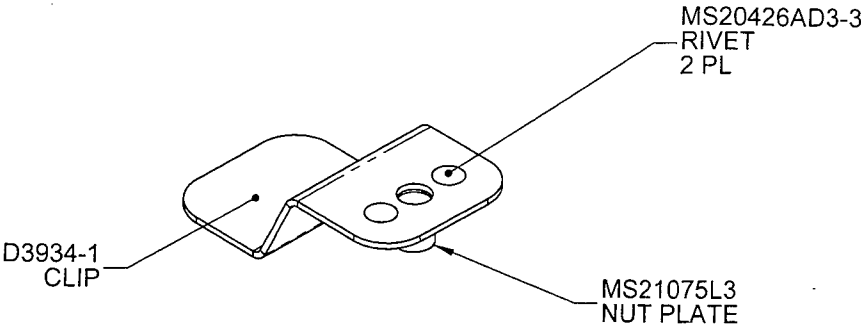
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
20 GAUGE (0.038 THICK)  
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3934	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CLIP ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



**D3934-041 CLIP ASSEMBLY**

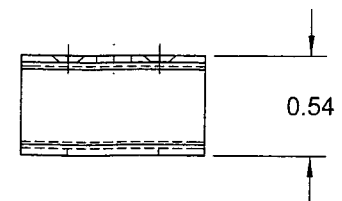
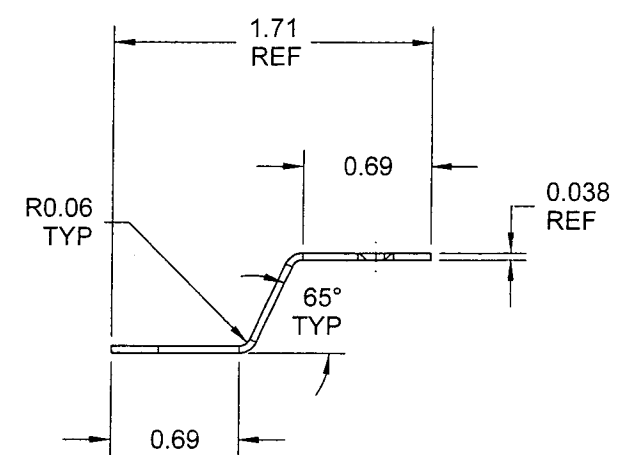
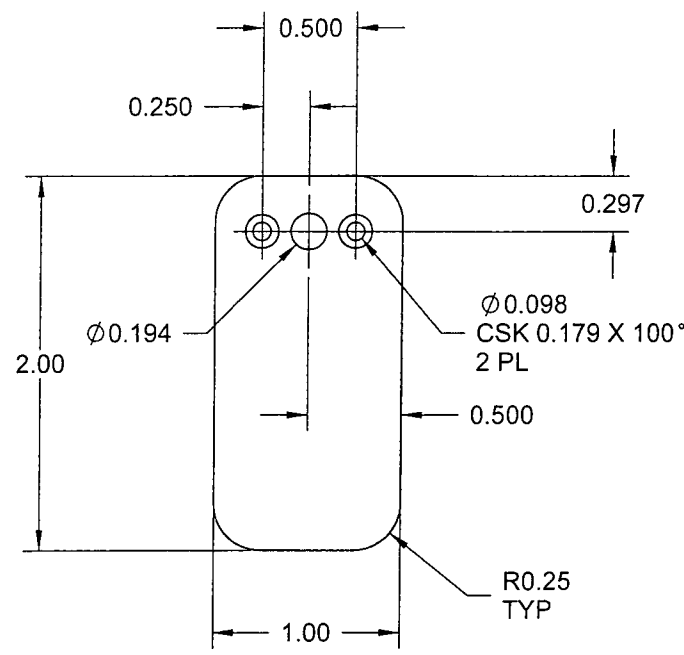
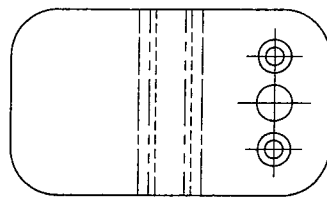
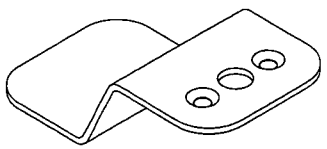
PROTOTYPE

09.04.22 PH

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3934	SHEET 1 OF 2
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DE APPR.	PH	CLIP ASSEMBLY	NTS
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







D3934-1F FLAT PATTERN 1

D3934-1 CLIP  
(MAKE FROM D3934-1F)

PROTOTYPE  
09.04.22

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
20 GAUGE (0.038 THICK)  
REF DART SPEC M304S20GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3934	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSEMBLY	NTS
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